

Date: Wednesday, 12/11/2008 1:37:39 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BELT GUIDE
Job Number : 43356	
Estimate Number : 13016	
P.O. Number :	Part Number : D36403
This Issue : 12/11/2008 S.O. No. :	Drawing Number : D3640 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 42132	Material :
Written By :	Due Date : 21/11/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.11.12</u>	
Comment : Est Rev:A New Issue 07-01-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNB075X1250	Delrin Bar
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Comment: Qty.: 0.4200 f(s)/Unit Total : 4.2000 f(s)

Black Delrin Bar

1.250" X .750"

BATCH: 1114535JUL 08/11/13

(10)

2.0	BAND SAW	BAND SAW
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Comment: Cut blank 3.8" long

JUL 08/11/13

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA670 & Dwg D3640 Rev: A

2-Deburr and Blend rad intersection with deburring tool.

JUL 08/11/13

(10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JUL 08/11/13

(10)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8/08/11/16

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:37:39 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BELT GUIDE

Job Number: 43356

Part Number: D36403

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 2101

JS 08/11/17 (213)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/17 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.11.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 43354
Description: Belt Guide		Part Number: D3640-3
Inspection Dwg: D3640	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

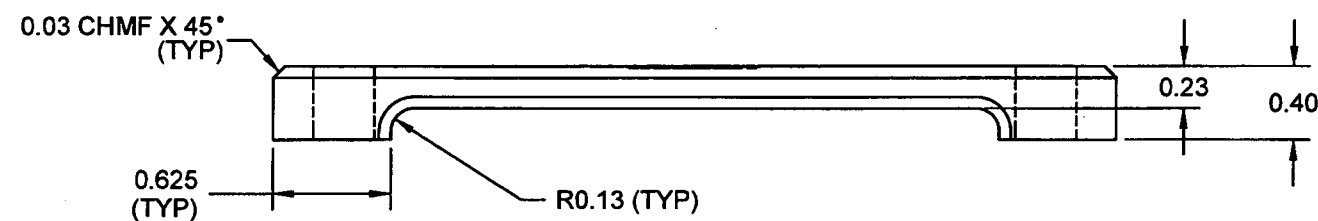
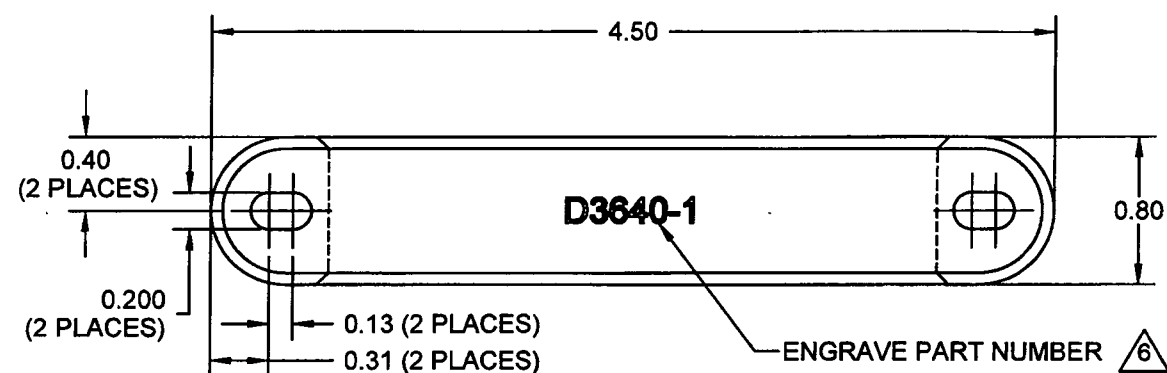
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.58	+/-0.030	3.580	—			
0.80	+/-0.030	.801	—			
0.13	+/-0.030	.128	—			
0.31	+/-0.030	.310	—			
0.200	+/-0.010	.200	—			
0.40	+/-0.030	.400	—			
0.03 x 45°	+/-0.030 x 0.5°	.025 x 45°	—			
0.23	+/-0.030	.237	—			
0.40	+/-0.030	.406	—			
0.625	+/-0.010	.630	—			
R0.13	+/-0.030	R.030	—			

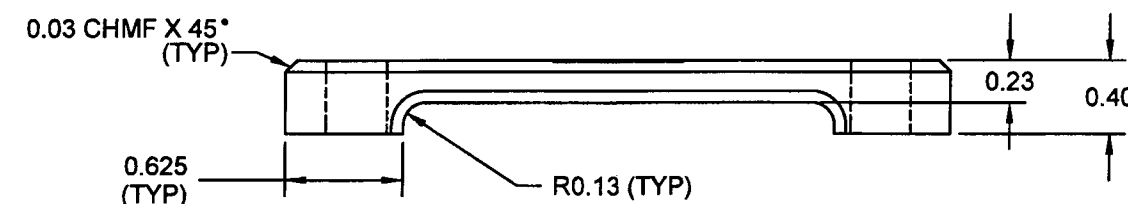
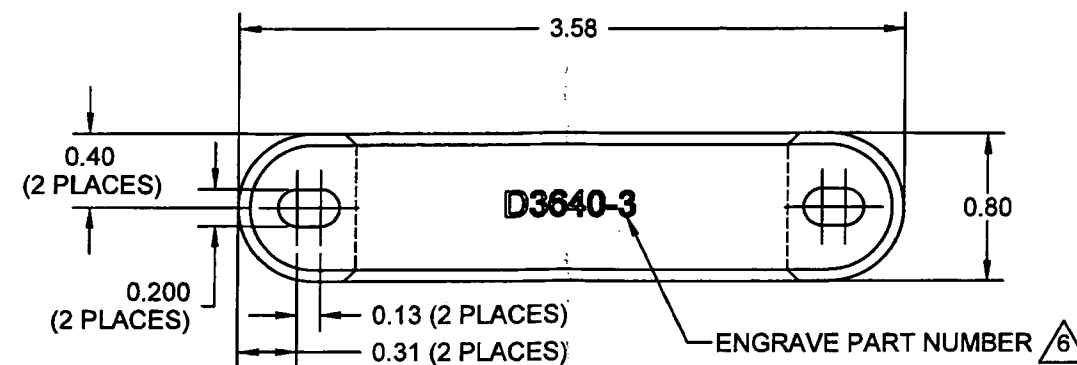
Measured by: <i>ML</i>	Audited by: <i>LF</i>	Prototype Approval:	N/A
Date: 08/11/13	Date: 08/11/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.19	New Issue	KJ/EC/DD	<i>DS</i>

8 7 6 5 4 3 2 1



D3640-1 BELT GUIDE
(WAS GENEVA P/N G10605-1)

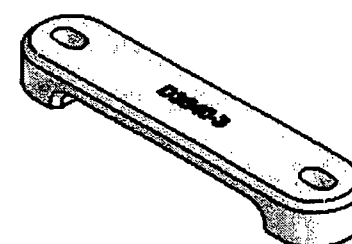


D3640-3 BELT GUIDE
(WAS GENEVA P/N G10605-2)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43354

RELEASED
07.09.01

- NOTES:
- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL BAR (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBERS TO MAX DEPTH OF 0.010 AT LOCATIONS SHOWN
 - 7) WEIGHT: 0.03 lbs



A	NEW ISSUE; REPLACES G10605		LE	07.07.27
REV.	DESCRIPTION		BY	DATE
DESIGN	TS LE B E H H	DART AEROSPACE USA, INC.		
DRAWN		PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D3640	SHEET 1 OF 1	
APPROVED		TITLE	SCALE	
DE APPR.		BELT GUIDE	1	
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